Work Order Wednesday, Febru						×					Page 1
Item ID: D Revision ID:	03201-3			Accept				s s	etup Star		
Item Name: D	oubler			*					Stop		
Start Date: 3/Required Date: 3/	/2/2011 /4/2011	Start Qty: 12.0 Req'd Qty: 12.0			Cust Item I Customer:	D:					
Reference:											wrrm 180 frag 1863
Approvals: l	Process Plan	::	Date://-02-	Tooling:	Da	ate:		R	un Star Stop		
	QC:		Date:	SPC (Y/N):	Da	ate:			Stop		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revis	sion Nbr						10.000		9.02	
D3201	Rev I	В									
		FLOW WATER JET		0.00				(D) 10	86 -6-1		
Waterjet		Memo		0.00					- 0- 00		
FLOW CNC Waterjet			per Dwg D3201 □Dwg I necessary	Rev: R □Prog Rev:_	<u>R</u> 🖂 2-					(ı	5
110 11 0		QC2- Inspect parts of	f machine FAI/FAIB	0.00	,	· ·					
QC		Memo		0.00				1.131	1-2-2B		
Quality Control		ivicano		0,000							
120 { 1111 11 	·	QC8- Inspect parts - s	second check	0.00	1.	í			_		
QC		Memo		0.00 Mes	2128			(416	}		
Quality Control								_			

.)

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
Part No	:	PAR #:	Fault Cateo	gory:	_ NCR: Yes	No DQ	A:	Date: _	
	Resc	olution:	Disposition	n:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORMA	ANCE (NC	R)			
		Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspecto
					-				



Page 2

Item ID:

D3201-3

Wednesday, February 23, 2011 3:27:18 PM

Accept

Tool # Plan

Code

Setup Start

Stop

Revision ID:

Item Name:

Required Date: 3/4/2011

Doubler

3/2/2011

Start Oty: 12.00

Req'd Qty: 12.00



Cust Item ID: Customer:

Reference:

Start Date:

Approvals	3:
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Process Plan:

Date:

Tooling:

Date:

Run Start

Reject

Qty

Accept

Qty

Date: _____

SPC (Y/N):

Date:

Tool ID

Stop

Number Stamp

Insp.

Reject

Sequence ID/ **Work Center ID**

130



Small Fab

Small Fab

Operation Description

Small Fab

Memo Deburr Stack Set Up/ **Run Hours**

0.00

0.00

140

Brake NC

NC BRAKE

Memo

Memo

0.00

0.00

Brake NC

1-Bend as per Dwg D3201 □2-Scribe part# and Batch# per dwg D3201

Sp 11/03/01
Sp 11/03/01

150

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Dart Ae	rospace	Ltd						
W/O:			WO	RK ORDER CHANGE	S			
DATE	STEP	PRO	CEDURE CHAN	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:						
NCR:				ER NON-CONFORMA				
		Description of NO		Corrective Action Section	n B	Verification	A	Ammunual
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
								·
		·					1	

Wednesday, February 23, 2011 3:27:18 PM

Item ID:

D3201-3

Accept



Setup Start



Stop

Item Name: **Start Date:**

Revision ID:

Doubler 3/2/2011

Start Qty: 12.00 Req'd Qty: 12.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ Date: ____

Tooling:

Date:

Run Start

Stop



Required Date: 3/4/2011

QC:

Date:_____

SPC (Y/N):

Date:

Tool # Plan

Accept Qty

Reject Qty

Reject Insp.

Sequence ID/ **Work Center ID**

160

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours**

0.00

Number Stamp

170

Quality Control

QC3- Inspect Part Finish

Memo

Identify as per dwg & Stock Location:

Memo

0.00

0.00

Code

180

Memo

0.00

0.00

Packaging

Packaging

Dart Aerospace Lt

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W/O:		dr.u.	WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _	
	Res	solution:	Disposition	າ:	_ QA: N/C (Closed:		Date: _	
NCR:		,	WORK ORDI	ER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC			ion B	Verifi	cation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sect	ion C	Chief Eng	QC Inspector
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Work Order ID 66679

Wednesday, February 23, 2011 3:27:18 PM



Page 4

Item ID:

D3201-3

Accept

Setup Start



Revision ID:

Item Name:

Doubler

Start Date:

Required Date: 3/4/2011

3/2/2011

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:_____

Date: _____

Tooling: SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop

Sequence ID/

Work Center ID

190

QC Quality Control

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ Run Hours

0.00

Tool ID

Tool # Plan Code Accept QtyReject Qty

Reject Insp. Number

Stamp

Memo

0.00

	Johnan								,
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRC	OCEDURE CHAP	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	gory:	_ NCR: Ye	s No D (QA:	Date: _	
	R	esolution:	Disposition):	_ QA: N/C	Closed: _		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NO	CR)			
DATE	STEP	Description of NC			ion B		ication	Approvai	Approval
DAIL	SIL	Section A	Initial Chief Eng	Action Description Chief Eng	Sig: Da		ction C	Chief Eng	QC Inspector
								į	

Picklist Print

Wednesday, February 23, 2011 3:27:25 PM

Work Order ID: 66679

Parent Item:

D3201-3

Parent Item Name: Doubler



Start Date: 3/2/2011

X

Required Date: 3/4/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev: A IPP Rev:B IPP Rev C

Removed from 9 Digit

Now on Wateriet

added scribing NCR262

06-01-25 JLM 06-08-14 JLM

07.11.29

EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	62.2847	0.045	0.568421	١,		
										1	D11-7-	D Ø	

2024-T3 .050 sheet

Location	Loc Qty	Loc Code		
MAT22	62.2847			6
111381	11.89			(الح)
113189	0.3947			\bigcirc
114968	50		114969	

W/O:	<u> </u>	· · · · · · · · · · · · · · · · · · ·	WC	ORK ORDER CHANG	GES					<u> </u>
DATE	STEP	PRO	CEDURE CHA			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
····										
Part No	:	PAR #:	Fault Cate	gory:	NCF	R: Yes I	No DQ	A :	Date:	
	R	esolution:	Dispositio	n:	QA:	N/C Clo	sed:		Date: _	
NCR:		1	WORK ORD	ER NON-CONFORM	IANCE	(NCR)			
DATE	STEP	Description of NC			ction B		Verific	cation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Initial Action Description Chief Eng Chief Eng			Sign & Section C		Chief Eng	QC Inspector
									,	

DART AEROSPACE LTD	Work Order:	46679
Description: Doubler	Part Number:	D3201-3
Inspection Dwg: D3201 Rev: B		Page 1 of 1

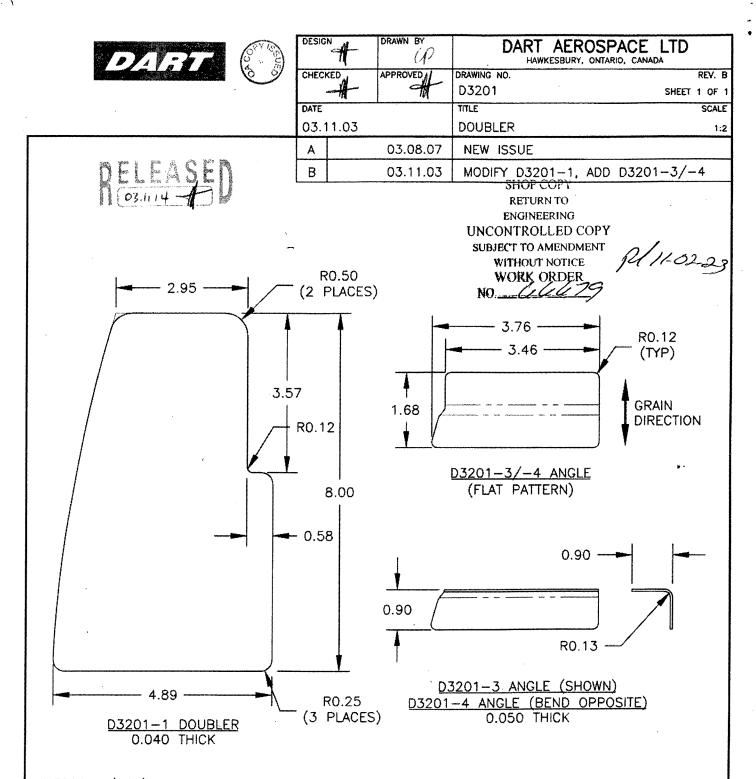
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.76	+/-0.030	3,764	×		U 1807	
3.46	+/-0.030	3,458	5		V	
1.68	+/-0.030	1.676	20		V	
0.050	+/-0.010	629	7		V	
			_			
	·		<u> </u>			
		· ,				- 11
					<u> </u>	

Measured by: iR	Audited by:	Preliminary Approval:	
Date: (1- 2-	Date: 11/02/25	Date:	

١	Rev	Date	Change	Revised by	Approved
	A	03.11.28	New Issue	KJ/RF	
	В	10.10.27	FAI sheet created for each part for D3201-3/-4 .	KJ 🛠	
				4/	

W/O:			W	ORK ORDER CHANG	GES					
DATE STEP		PROCEDURE CHANGE			[Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No: PAR #:		PAR #:	Fault Cate	gory:	NCR	Yes 1	lo DQ	A:	Date:	
		esolution:	Disposition:		QA:	QA: N/C Closed:			Date:	
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR))		-	
DATE	STEP	Description of NC	Corrective Action Section			Verificati		cation	n Approval A	Approval
DATE		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	& Section C		Chief Eng	QC Inspector
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]	1	}	[l		1		1	



D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)

(REF. DART SPEC M2024T3S)

- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:	······		W	ORK ORDER CHANG	FS				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	_ Fault Cat	egory:	_ NCR: Yes	No DQ	A:	Date:	
Resolution:			Dispositi	_ QA: N/C Closed:			Date:		
NCR:		W	ORK ORI	DER NON-CONFORMA	NCE (NC	R)			
	STEP	Description of NC Section A		on B	Verif	cation	Approval	Approval	
DATE			Initial Chief Eng	Action Description Chief Eng	Sign Date		tion C	Chief Eng	QC Inspector
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